

Date: Monday, 6/5/2006 7:38:18 AM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOOR ASSEMBLY	
<b>Job Number</b> :	27340C			
<b>Estimate Number</b> :	12353			
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D41269403	
<b>This Issue</b> :	6/5/2006	<b>S.O. No.</b> :	N/A	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D412-694	
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	27323C	<b>Drawing Revision</b> :	C1	
		<b>Material</b> :	N/A	
<b>Written By</b> :		<b>Due Date</b> :	7/15/2006	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i> 06.06.05			
<b>Comment</b> :	Est Rev: A 05.12.09 New Issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Issue red decal labels for D412-694-03. CHG005

2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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**Comment:** COMPOSITE ASSEMBLY

D412-694-03 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.

✓ 2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.

✓ 3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3113-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).

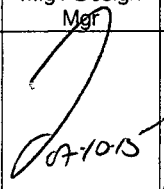
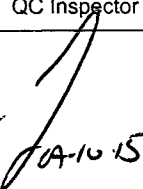
4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF).

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).

*[Handwritten signature]*  
PTO  
07/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
07/10/11	2	The jig DT 3144-T4 do not exist Use drawg for making holes.	mf	07/10/11		 07-10-15	 07-10-15

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Monday, 6/5/2006 7:38:18 AM  
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## Process Sheet

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Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



*Remove - 11/07/10/15*



Comment: INSPECT WORK TO CURRENT STEP

*N/A ml 07/10/11*

4.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

*M15893*

*M104835*

*17 May 2008*

*✓ ml*

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

*ml 07/10/15*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

*17-10-15*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

*45 07-10-16*

8.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

*Er 07/10/16*

9.0

D31101

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

*B24673*

*CP*

10.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

*B27539*

*CP*

*CP 07/09/180*

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Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Plate Assembly

Batch

M10536-17

*EP*

12.0

D31121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guide

Batch

B 35234

*ml*

13.0

D31131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spring

Batch

D27366

*EP*

14.0

D31141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pivot

Batch

B18630

*EP*

15.0

D31165

Seal 110-031-4



Comment: Qty.: 5.6700 f(s)/Unit Total: 5.6700 f(s)

Seal 110-031-4

Batch

B27208

*EP*

16.0

D311611

SEAL



Comment: Qty.: 1.5000 f(s)/Unit Total: 1.5000 f(s)

SEAL

Batch

B24675

*EP*

17.0

D3119041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover Assembly

Batch

D27724

*EP*

*EP 07/09/180*

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D31201

Cover, Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover, Flat Pattern

Batch

M10536-17

CP

19.0

D31203

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover

Batch

M10536-17

CP

20.0

D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

CP

21.0

D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

CP

22.0

D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

CP

23.0

D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

CP

24.0

D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Lever

Batch

M10536-17

CP

CP 07/09/180

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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D31301

Clevis Base



CP.



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis Base

Batch

M10536-17-

26.0

D31311

Stop



CP.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Stop

Batch

M10536-17-

27.0

D31341

Rod



CP.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod

Batch

B27338-

28.0

D31343

Rod



CP.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod

Batch

~~M10536-17~~ B24682

✓ ml

29.0

D314007

Door Kit



CP.



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Door Kit

Batch

B27340C

ml

30.0

D31431

Clevis



CP.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

Batch

M10536-17-

31.0

D31433

Clevis



CP.



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Clevis

Batch

B18816-

CP 07/09/180

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D31441

Doubler



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B18816 -

33.0

D3144105

Doubler



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B23143 -

34.0

D3144107

Doubler



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

D23144 -

35.0

D31451

Bracket



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B26502 -

36.0

D31461

Hinge Bracket



CP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

Batch

D26709 -

37.0

D31471

Pin



CP



ml ✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

B30824

38.0

D31491

Striker Plate



CP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch

M10536-17 -

CP 04/09/18 @



W/O:		WORK ORDER CHANGES					
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Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D31501

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

M10536-17

40.0

D31541

Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch

A1053617

EP

41.0

D31571

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M10536-17

EP

42.0

D3159041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

D18641

EP

43.0

D3159043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24707

EP

44.0

AN52510R7

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M104214

EP

45.0

AN960JD6L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M15519

EP

EP 07/09/18 @

W/O:		WORK ORDER CHANGES					
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Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M104374

47.0

AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M16956-

48.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch

M104885

49.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

M103044-

50.0

AN960JD10LL

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

M19600-

51.0

ALS463280

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

M17841-

52.0

BSP45

Commercial Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

Batch

M11821-

07/09/18

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

BSP46

Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Commercial rivet  
Batch M169098-

*[Signature]*

54.0

FW4032

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Washer  
Batch M11822-

*[Signature]*

55.0

FW10032

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Washer  
Batch M101203-

*[Signature]*

56.0

M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
*[Initials]* Rivets  
Batch M15659

*[Signature]*

57.0

M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Rivet  
Batch M1108-

*[Signature]*

58.0

MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M18822-

*[Signature]*

59.0

MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M14149-

*[Signature]*

*[Signature]* 7/10/180

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Seq. #:

Machine Or Operation:

Description :

60.0

MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M11796

EP



61.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M104936

EP



62.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M104603

EP



63.0

MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

EP



64.0

MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15924

EP



65.0

MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15798

EP



66.0

MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

M104407

EP



EP 07/09/18

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Job Number:



Seq. #:

Machine Or Operation:

Description :

67.0

MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M104407-

*EP*

68.0

MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

M19098-

*EP*

69.0

MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M11754-

*EP*

70.0

MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M104215-

*EP*

71.0

MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11735-

*EP*

72.0

MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M11786-

*EP*

73.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M11822-

*EP*

*EP 07/09/180*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:38:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

74.0

NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M11753-

75.0

NAS38868P

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M19098-

76.0

NAS391B6P

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Batch

M19098-

77.0

NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M11737-

78.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Monday, 6/5/2006 7:38:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.  
Note: Position strike plate when big door is in locked position.

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3.

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

17- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

79.0

QC5

INSPECT WORK TO CURRENT STEP


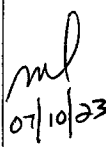
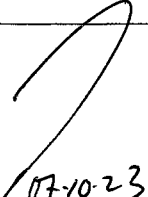
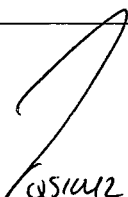
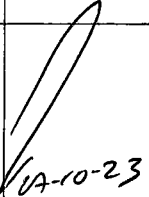
79.A



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/10/23	79	Have to replace Seal D3116-S-0680 Seal was torn.	 QSIW2	Took out one D3116-S-0680 x1 Took out BSP45 x47 SCVAP QTY 1 Replace them by new D3116-S-0680 x1 <u>B23699</u> BSP45 x47 <u>M11821</u>	 ml 07/10/23	 07-10-23	 QSIW2	 QA-10-23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:38:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

80.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CY 07110124

①

81.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D07110125

Job Completion



U 57-1024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-894-01	DOOR ASSEMBLY
	X			D412-894-02	DOOR ASSEMBLY
		X		D412-894-03	DOOR ASSEMBLY
			X	D412-894-04	DOOR ASSEMBLY
			1	D3110-1	ESCUITEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-6-0880	SEAL
1	1			D3116-7-0880	SEAL
1	1			D3116-8-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (TOLLER)
1				D3121-043	BRACKET ASSEMBLY (TOLLER)
		1		D3121-044	BRACKET ASSEMBLY (TOLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
		1		D3132-042	ROD WELDMENT
		1		D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
		1		D3138-1	COVER
		1		D3138-2	COVER
		1		D3139-1	GUARD
1				D3139-3	GUARD
		1		D3139-4	GUARD
1				D3140-05	DOOR
		1		D3140-06	DOOR
		1		D3140-07	DOOR
		1		D3140-08	DOOR
		2		D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
		1		D3144-3	DOUBLER
		1		D3144-105	DOUBLER
		1		D3144-107	DOUBLER
		1		D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
		1		D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
		1		D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
		1		D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (TOLLER)
		1		D3183-042	BRACKET ASSEMBLY (TOLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-28	INSERT (OR SL2022-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN650D10	WASHER
18	18	4	4	AN650D10L	WASHER
13	13	32	32	AN650D10LL	WASHER
6	6			AN650D14H	WASHER
		4	4	AN650D18	WASHER
6	6			AN650D18	WASHER
		2	2	AN650D18L	WASHER
		2	2	AN650D18LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	80	80	BSF45	RIVET
		12	12	FW10-32	WASHER
		6	6	FW4-32	WASHER
12	12			M7885-24	RIVET (OR OR3214-3)
		3	3	M7885-34	RIVET (OR OR3214-3)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	Rivet
8	8			MS20426AD4	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L06	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT/PLATE
6	6	9	9	MS24655-151	COTTER PIN
4	4			MS24655-3271	SCREW
		2	2	MS24659-04	SCREW
4	4			MS24659-05	SCREW
6	6			MS24659-06	SCREW
18	18			MS24659-080	SCREW
		4	4	MS24659-056	SCREW
		2	2	MS24659-063	SCREW
		4	4	MS24659-080	SCREW
4	4			MS24659-088	SCREW
		2	2	MS25281-F6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS36208-231	SCREW
2	2			MS36275-233	SCREW
2	2			MS36449-264	NUT
		4	4	MS36550-3057	NUT
2	2			MS36550-3252	NUT
2	2	3	3	MS31859-7	WASHER
		4	4	MS31859-10L	WASHER
		14	14	MS3366-6P	SCREW
		15	15	MS33185P	WASHER
7	7			NAS430D3-10	SPACER
6	6			NAS430D3-14	SPACER
		2	2	NAS430D3-40	SPACER

#### GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOFF SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, 830-2000-01; D3144-T4-T2-T3; D3183-3; D3162-041T1 (FOR -01 DOOR ASSY); 830-2000-02; D3144-T4-T9-T8; D3183-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4-T9-T8; D3183-041T1; D3112-T4-T2 (FOR -03 DOOR ASSY); D3144-T4-T9-T8; D3112-T4-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER PART Q3 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER PART Q3 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-894-01/02-03/04 DOOR ASSEMBLIES USING D2729-1 DECALS.

C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
		SCALE NTS

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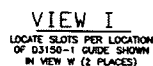
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10 21 20



D412-694-03 DOOR ASSY (SHOWN)  
D412-694-04 DOOR ASSY (OPP)


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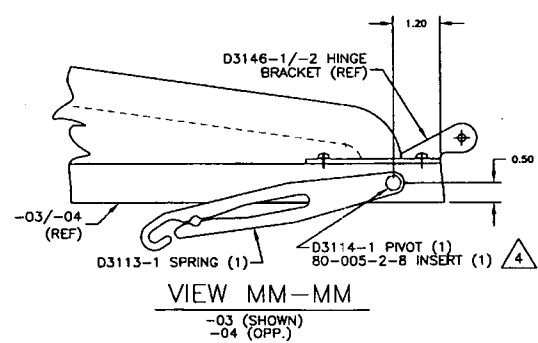
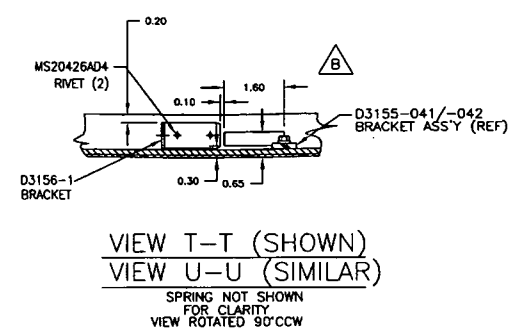
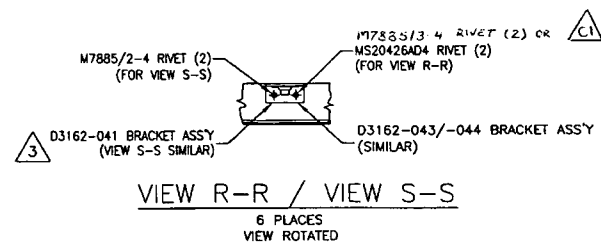
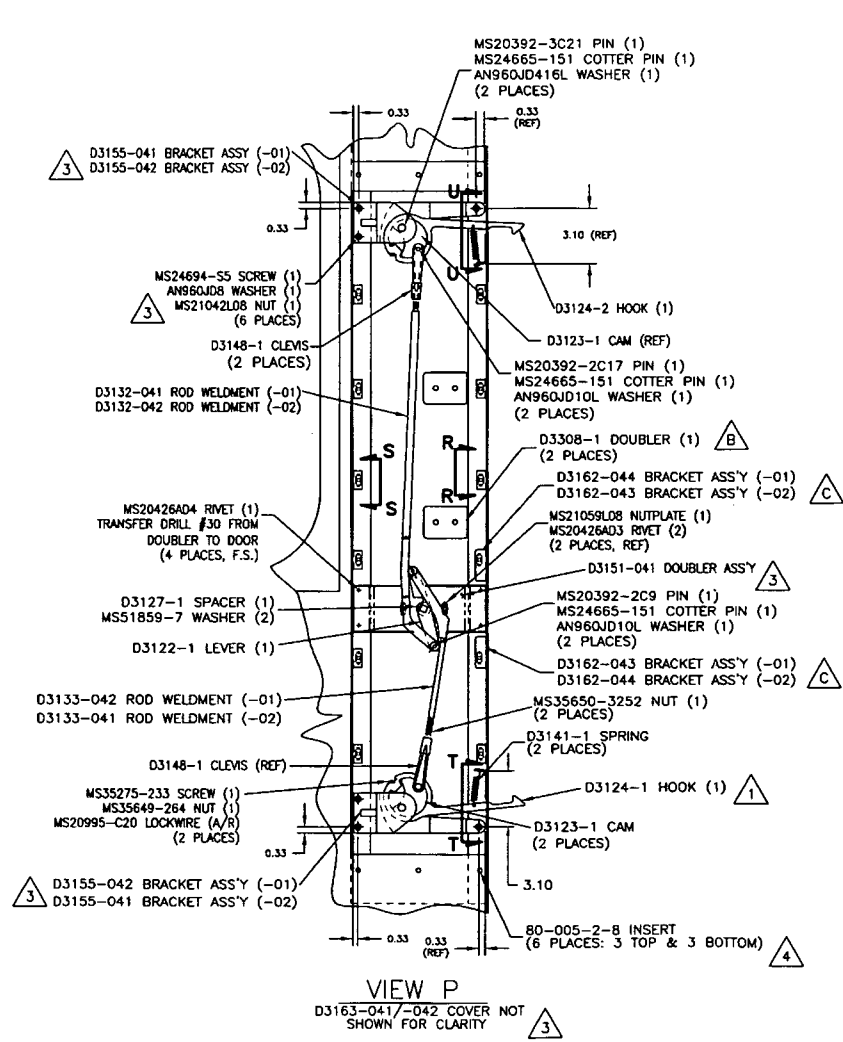
DESIGN	CP
CHECKED	
DATE	05.11.23

DRAWN BY	RF
APPROVED	

<b>DART</b>
DRAWING NO. D412-694
TITLE DOOR ASSEMBLY

**DART AEROSPACE LTD.**  
MANNESBURY, ONTARIO, CANADA


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 WORK ORDER  
 NO. 27340 c



NO. 27970 C

WORK ORDER

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SUBJECT TO AMENDMENT

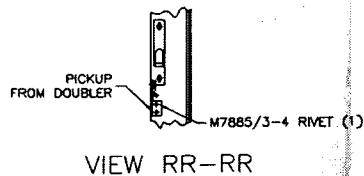
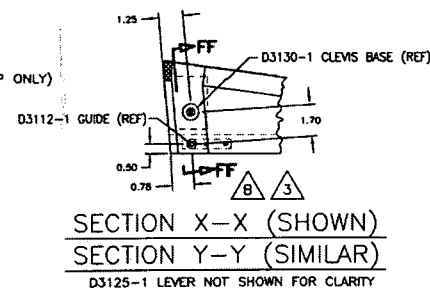
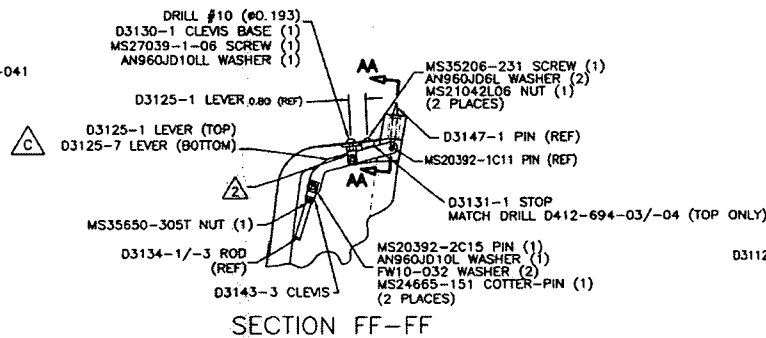
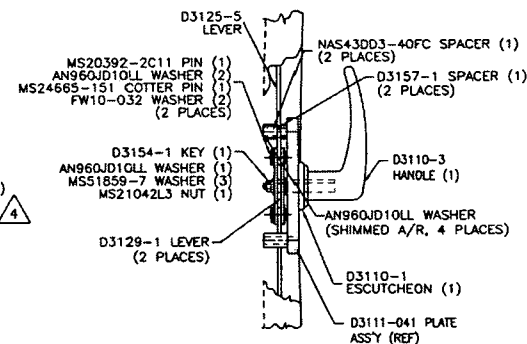
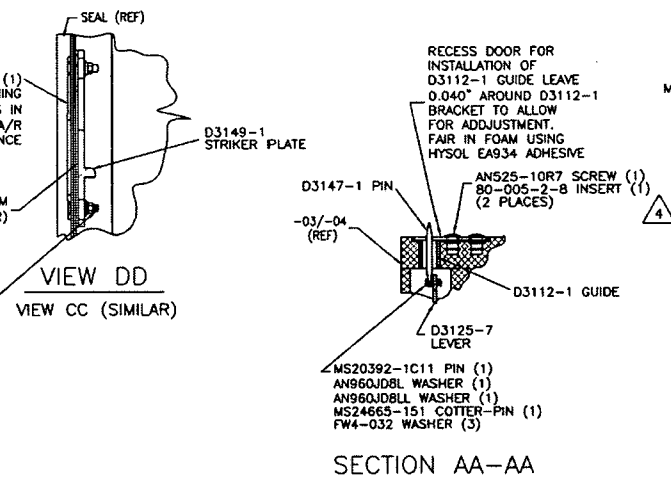
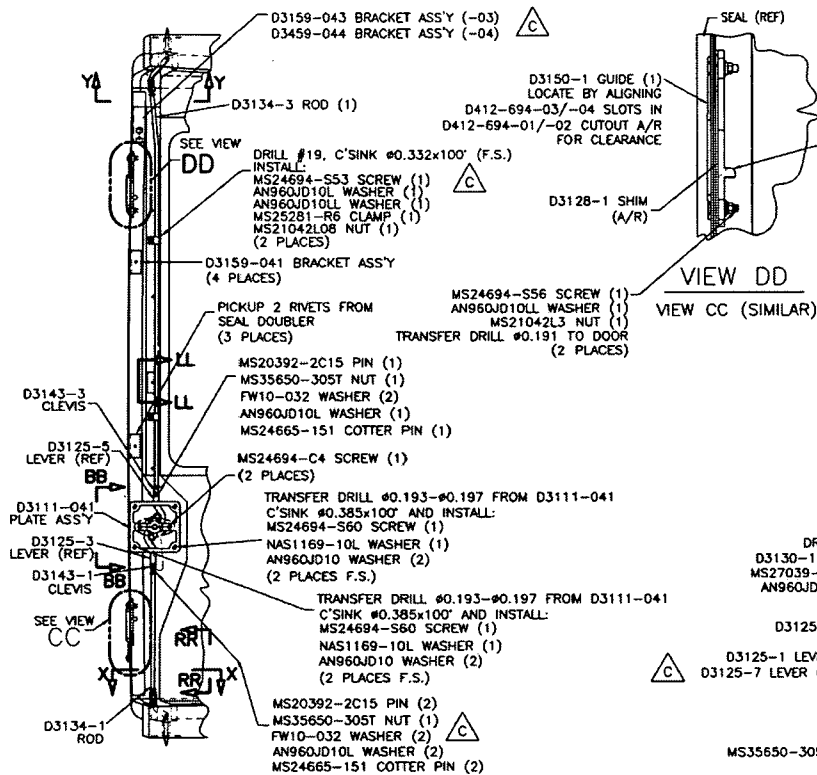
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	

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05/12/01



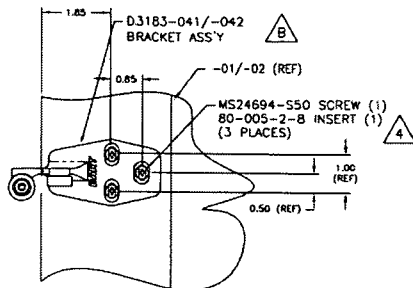


SECTION LL-LL  
(3 PLACES)  
VIEW ROTATED 90°CCW

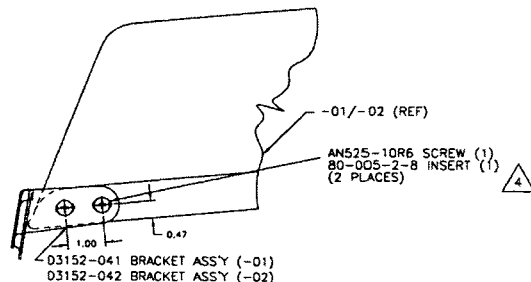
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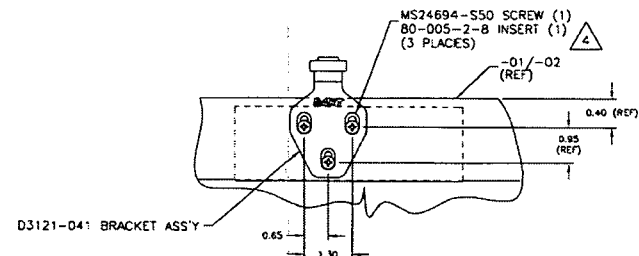
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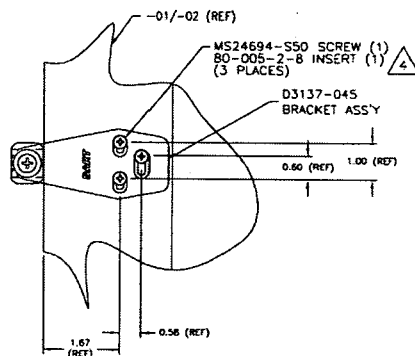
VIEW J



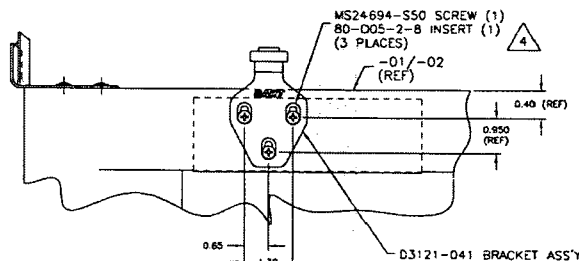
VIEW Q



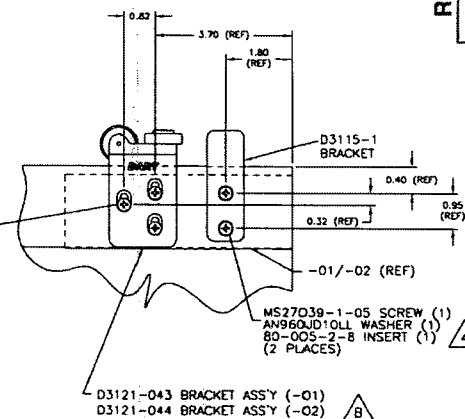
VIEW L



VIEW H





MS24694-S50 SCREW (1)  
80-005-2-8 INSERT (1)  
(3 PLACES)



VIEW M

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